

Work Order ID 104994

104994

Page 1

July-23-13 12:58:31 PM

Item ID: D4029-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: WEBBING (LONG BASKET)

Stop

NS2

Start Date: 7/23/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/23/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MLC

Date: 13-07-25

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4029	A								

100 *100* PURCHASING 0.00

Purchasing

Memo

0.00

13-07-29

Issue P/O: 20714
Fabricate D4029-041 as per Dwg D4029
Possible Supplier: Aerotex or Tulmar
Material release note is required

110 *110* Packaging 0.00

Packaging

Memo

0.00

Ensure Material Release Note is attached

13/8/2 (4)

120 QC 0.00

QC

Memo

0.00

Quality Control

DAS

27

9-89

14 SP 13-8-19 Pb →

4

13-8-26

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: *John*Date: *13/09/16*QA Closed: *OK*Date: *13/09/16*

Work Order: <u>104994</u>	DISPOSITION				AGAINST DEPARTMENT/PROCESS			
Part No. <u>D4029-04</u>	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
NCR No. <u>NCR 13-2915</u> - See <u>B-3031</u>	Scrap <input checked="" type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
	Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input checked="" type="checkbox"/>				

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data				Found at ins packis multiple reason to fail all parts.	DAS 16 9-89	inform supplier + return all defective parts.	See NCR 13-2915	DAS 27 9-89	
Equip/Tooling				- Dim 7.1 ± .02 is 7.62"					
Operator				- detail B is stucked incorrectly wrong direction					
Material				- All runs are leap frog / buckles (screws) should be all sticki up.					
Setup	<i>13/08/16</i>	<i>120</i>	<i>10</i>		<i>Q37042</i> <i>13/08/16</i>	verify new parts to ensure they conform to drawing. <i>Q37042</i>	<i>5</i> <i>13/08/16</i>		<i>Q37042</i> <i>13/08/16</i>
Other									
Process									
Supplier									
Training									
Unapproved									

R.C. made incorrectly.

FAULT CATEGORY

Landing Gear		General									
		<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Pressure/Forced					
		<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Temperature/Cure					
		<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Weld					
		<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled					
		<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved						
		<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input checked="" type="checkbox"/> Positioned Wrong						
		<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge						
		<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset							
		<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration							
		<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence							
		<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions							

Work Order ID 104994

104994

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July-23-13 12:58:31 PM

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Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: WEBBING (LONG BASKET)

Stop

NS2

Start Date: 7/23/13 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 7/23/13 Req'd Qty: 4.00 *4*

Customer:

Reference:

Approvals:

Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00

13/8/26 (4)

130

Packaging

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

13/9/18 (A)

140

QC

Quality Control

Memo

0.00

13/8/26

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear	General										
	<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Pressure/Forced						
	<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Temperature/Cure						
	<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Weld						
	<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled						
	<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved							
	<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong							
	<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge							
	<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset	<input type="checkbox"/> Other							
	<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration								
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence									
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions									

Picklist Print

July-23-13 12:58:31 PM

Page 1

Work Order ID: 104994**Parent Item:** D4029-041**Parent Item Name:** WEBBING (LONG BASKET)**Start Date:** 7/23/13**Required Date:** 7/23/13**Start Qty:** 4.00**Required Qty:** 4.00**Comments:** IPP RevA: new issue DD 10.01.12 verified by:EC
10.03.15 verified by:EC

IPP Rev:B rev.A as per dwg DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4029-041P Webbing (Long Basket)		Purchased	No			110	Each	0.0000	1	4		1/3/14 2 (4)	

4 x SP13-8-19.

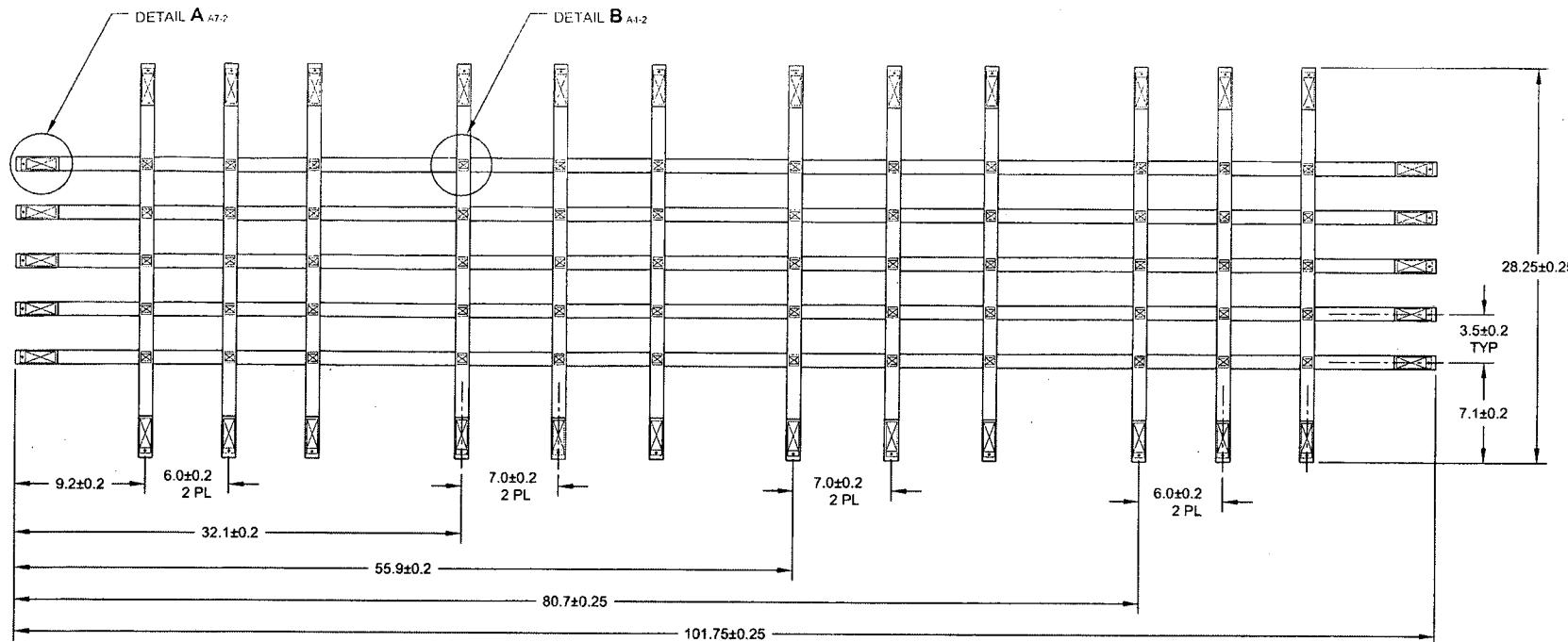
NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____	<input type="checkbox"/> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update		Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>				
NCR No. _____										
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										
FAULT CATEGORY										
Landing Gear				General						
	<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Pressure/Forced					
	<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Temperature/Cure					
	<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Weld					
	<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled					
	<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved						
	<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong						
	<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge						
	<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset		<input type="checkbox"/> Other					
	<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration							
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence								
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions								



D4029-041 WEBBING (LONG BASKET)

RELEASED
2010-03-12
AMP

NOTES:

- 1) MATERIAL: WEBBING MATERIAL: NYLON, MIL-W-4088K, TYPE XVII, CLASS 1A, COLOR RED
THREAD: NYLON THREAD TO BE USED FOR ALL SEAMS CONFORMING TO V-T-295 TYPE II,
CLASS A, SIZE F, COLOR RED
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4029-041: 2.0 lbs, D4029-043: 1.5 lbs
- 8) ALL STITCHING TO BE MACHINE STITCHED IN ACCORDANCE WITH ASTM D6193 TYPE 301,
8-10 STITCHES PER INCH, MINIMUM 0.5" BACK STITCH
- 9) HOT CUT WEBBING ENDS TO PREVENT FRAYING

A	NEW ISSUE	JPH	10.03.04	
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD		
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA		
CHECKED	J	DRAWING NO.	REV. A	
MFG. APPR.	J	D4029	SHEET 1 OF 2	
APPROVED	N	TITLE	SCALE	
DE APPR.	N	WEBBING, 350 BASKET	NTS	
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

8 7 6 5 4 3 2 1

104994 MCS
13-07-25



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO20714

Purchase Order Date 7/29/2013

PO Print Date 7/29/2013

Page Number 1 of 1

Order From : VC-AFR003

AEROTEX INTERIORS INC.
2340 PEGASUS WAY NE
UNIT 151
CALGARY, AB T2E 8M5
CA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name		Buyer	Brigitte Golden
Vendor Phone	403 295 8770	Customer POID	
		Customer Tax #	10127-2607
Ship To Contact		Terms	Net 30
Ship To Phone		Currency	CAD
Ship Via:		FOB	Destination-Collect
Ship Acct:			

Line Total: **\$1,160.00**

PO Total: \$1,160.00

Note: Pricing listed above is as per contract agreement between Dart Aerospace and the respective manufacturer.
No substitution or deviation without consent.
Certificate of Conformity or Material Certification required - YES NO
PST# 6122-5207

Change Nbr:

1

Change Date: 7/29/2013



151-2340 Pegasus Way NE
Calgary, AB T2E 8M5
PH: 403.295.8770 FX: 403.313.0793
EM: info@aerotex.ca WS: www.aerotex.ca

Packing Slip

Date Packing Slip

01/08/2013 13-0471

Ship: Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA

Bill: Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7
CANADA

Customer Phone
613.632.5200

Customer Fax
613.632.1053

Email: PURO ACCT 1-7684382

Ship Via
Fedex P1

Courier Acct No.

Ship Date P.O. No.
01/08/2013 PO20714

ID	Description	Part Number/Color	Back Order	Shipped	Qty
DART	WEBBING (LONG BASKET) GST On Sales	D4029-041P			4

Thank you for doing business with Aerotex Interiors!

GST/HST No.

139110308

"your one stop shop for all your aircraft interior needs"
www.aerotex.ca

1. Organization issuing certificate. Aerotex Interiors Inc., 151-2340 Pegasus Way NE Calgary, AB T2E 8M5	2.	3. Work Order / Contract / Invoice 13-0471
---	----	--

CERTIFICATE OF CONFORMANCE

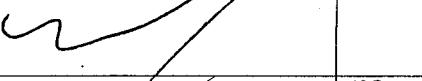
4. Customer Name/Address DART Aerospace LTD 1270 Aberdeen Hawkesbury, ON K6A 1K7 CANADA	5. Purchase Order PO20714
---	---

6. Unit	7. Materials Used for Items	8. Specifications	9. Batch	10. Item	11. Part Number	12. Quantity	13. Status
1	44mm WEBBING	MIL-W-4088K T XVII	6113	Long Basket – Webbing	D4029-41P	4	NEW
2	Nylon Thread RED	V-T-295 Type II	5015				

14. Remarks

I certify that the materials supplied for the Purchase/Repair Order listed above conform to Aerotex Interiors's material/process specification and are in all respects in conformance with the contract requirements. I further certify that the materials meets and complies with DWG. D4029 REV. A

Burn test requirements

15. Signature	16. Title
	Manager
17. Name	18. Date
Carson Chanthivong	August 07, 2013

e 8/20



Non-Conformance Report

Printed on:

Thursday, August 08, 2013

Raised Date 8/8/2013	Status Open	Owner Gregoire, Michael	Number NCR13-2915
Target Date 8/30/2013	Standard		Severity MAJOR
Process Quality Inspection	Audit		
Raised By Person Downing, Eric M	Raised Against (Department or Supplier) Aerotex Interiors Inc.		Fault Category Other\Supplier
Details during incoming inspection on D4029-041 B104994 PO#20714 it was found that the webbing's didn't match the drawings. many mistakes were found during the inspections.1- the webbing is in a over/under pattern when the drawings do not call for that. the drawing specifies that the webbing be stitched over 2- the extensions of 7.1" +/- 0.2" measures 7.625" on some ends3-the "X" stitching (detail B on the drawing) are in the wrong orientation4- pointed out by Mike that there is a glue between the stitching all issues need to be addressed for the next batch of webs to be approved			
Product D350-607\ D4029-041			
Document		Root Cause	
Closed By	Closed Date	Resolution	

Target Date 8/30/2013	Owner Forbes, Nigel	Closed Date	Closed By
Details			

Actions		Owner	Target Date	Completed Date
Number	Details	Response		
1	Gregoire, Michael	8/16/2013		
contact supplier and inform them of all the issues found				
2	Gregoire, Michael	8/23/2013		
request for a RMA # and return faulty parts				
3	Gregoire, Michael	8/23/2013		
find the reason root cause of the failure to match the drawings		internal mis information, correction made glue being used Hysol 7802 FR		

Verification : <input type="checkbox"/>			
Target Date	Owner	Closed Date	Closed By
8/12/2013			
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	

AEROTEX

151-2340 Pegasus Way NE
Calgary, AB T2E 8M5
PH: 403.295.8770 FX: 403.313.0793
EM: info@aerotex.ca WS: www.aerotex.ca

Packing Slip

Date Packing Slip#

14/08/2013 13-0471

Ship: Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA

Bill: Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7
CANADA

Customer Phone
613.632.5200

Customer Fax
613.632.1053

Email: PURO ACCT 1-7684382

Ship Via
Fedex P1

Courier Acct No.

Ship Date P.O. No.

14/08/2013 PO20714

ID
DART

Description

WEBBING (LONG BASKET)
GST On Sales

Part Number/Color Back Order Shipped Qty

D4029-041P

4

Thank you for doing business with Aerotex Interiors!

GST/HST No.

139110308

"your one stop shop for all your aircraft interior needs"
www.aerotex.ca